

Work Order ID 65968

January 31, 2011 8:30:19 AM



Page 1

Item ID: D3535-31

Accept



Setup Start



Revision ID: .

Stop



Item Name: Wearshoe

Start Date: 1/31/11 Start Qty: 6.00



Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 6.00



Customer:

Reference:

Run Start

Approvals: Process Plan: CL Date: 1/10/11

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3535

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessaryB11-1-31

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-1-31(x7)

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5/10/11x6Pro

W/O: 65968		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/01/31	#120	Took Qty 1 For inspection template	S	11/01/31	1		S 11/01/31

Part No: D3535-31 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65968

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Item ID: D3535-31

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 1/31/11 Start Qty: 6.00



Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Brake NC

NC BRAKE

Memo

0.00

Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326. ☐ Identify as D3535-31.

SB 11/21/31

(6)

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

SB 11/21/31

(16)

Quality Control

150

0.00



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

0.00

START TIME: 1:30 ☐ OVEN TEMPERATURE:
320° FINISH TIME: 2:00

M 115128

6 BL 11-02-1

Powder Coating

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65968

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Page 3

Item ID: D3535-31

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 1/31/11 Start Qty: 6.00



Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

JA

11/02/02

6

0

Quality Control

170

Identify as per dwg & Stock Location: FP-20 0.00

Packaging

Memo

0.00

Packaging

6

BR 11-02-1

180

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

11/02/02

MF

11-02-01

Picklist Print

January 31, 2011 8:30:18 AM

Page 1

Work Order ID: 65968

Parent Item: D3535-31

Parent Item Name: Wearshoe



Start Date: 1/31/11

Required Date: 2/04/11

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S20GA		Purchased	No			100	sf	170.3538	0.5955	3.761053			
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304/316 .040 Sheet



Bill - 1-31

Location

Loc Qty

Loc Code

MAT

170.3538

115953

21.6

116437

52.7538

116623

96

116623

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 65968
Description: WEAR PLATE	Part Number: D3535-31
Inspection Dwg: 3535-31 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .188	+ .005 - .001	.191	✓		V HB02	
.300	± .010	.310	✗		V	
.300	± .010	.307	✓		V	
1.885	± .010	1.890	✓		V	
2.000	± .010	1.998	✓		V	
6.00	± .030	6.00	✓		T HB01	
6.75	± .030	6.75	✓		T	
6.000	± .010	6.000	✓		T	
9.500	± .010	9.500	✗		T	
14.250	± .010	14.250	✓		T	
19.000	± .010	19.000	✓		T	
22.500	± .010	22.500	✓		T	
13.50	± .030	13.50	✓		T	
.040	± .010	.035	✓		V	

Measured by: B	Audited by: D	Preliminary Approval:
Date: 11-1-31	Date: 11/01/31	Date:

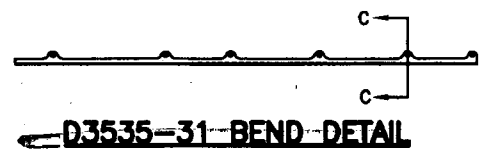
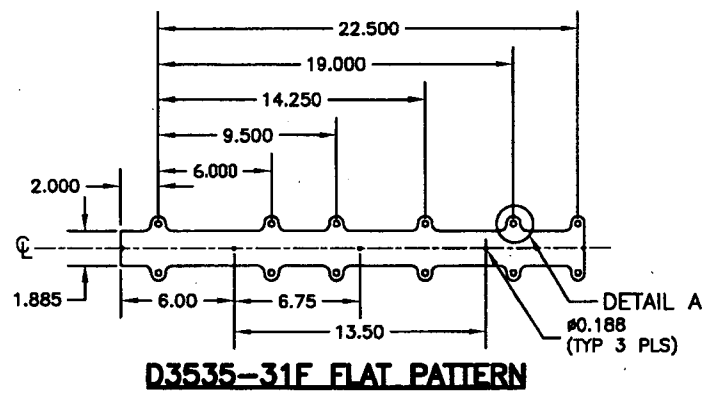
Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

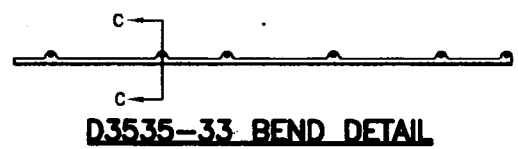
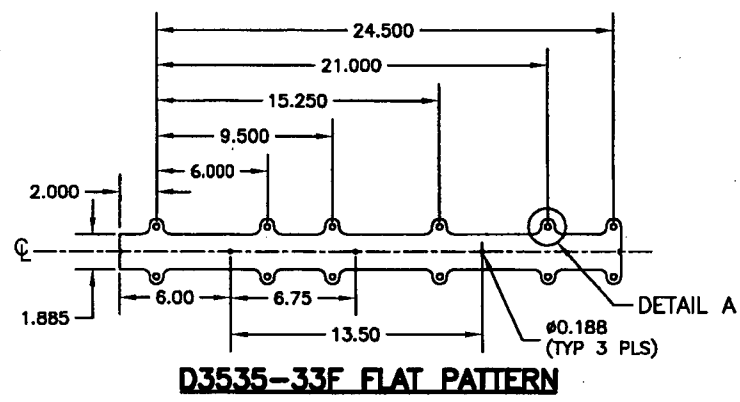
DART

RELEASED
07.04.24

DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 4 OF 7
	SCALE 1:10	



0211101131
W10:65968



NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION